

Work Order ID 155538

Tuesday, January 17, 2017 11:25:38 AM

155538

Page 1

Item ID: D2353

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stiffener

Start Date: 1/9/2017

Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/17/2017

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

JAN 18 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2353

Rev C

100

0.01

100

Waterjet

FLOW WATER JET

Memo

0.02

FLOW CNC Waterjet

1-Cut as per Dwg D2353 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

⑥

2-17/02/07

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

Quality Control

⑥

2-17/02/07

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.02

Quality Control

⑥

DAS
38
3-89

FEB 08 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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155538

N900040100

(x6) 201702
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Work Order ID 155538

155538

Page 3

Tuesday, January 17, 2017 11:25:38 AM

Item ID: D2353 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stiffener
 Start Date: 1/9/2017 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 1/17/2017 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.01							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:55 OVER TEMPERATURE: FINISH TIME: 8:25								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.01							
Quality Control									

FEB 24 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 155538

Tuesday, January 17, 2017 11:25:38 AM

155538

Page 4

Item ID: D2353

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Stiffener

Start Date: 1/9/2017

Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/17/2017

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: 81225A 0.00

180

Packaging

Memo

0.01

Packaging

6x

DAS
26
9-89

FEB 27 2017

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.08

Quality Control

17/2/28 J

DAS
21
9-89

FEB 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER :																					
Misidentified ☐		Past Due ☐																							

Picklist Print

Tuesday, January 17, 2017 11:25:37 AM

Page 1

Work Order ID: 155538

155538

Parent Item: D2353

D2353

Parent Item Name: Stiffener

Start Date: 1/9/2017

Required Date: 1/17/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
IPP: B 06.11.15 waterjet EC
IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased		No		100	sf	74.1000	0.1463	0.77			

M2024T3S 050

2024-T3 .050 sheet

01/17/02/07

Location

Loc Qty

Loc Code

MAT022

74.100026

m131564

1.8

m134581

32.1

m135610

40.200026

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

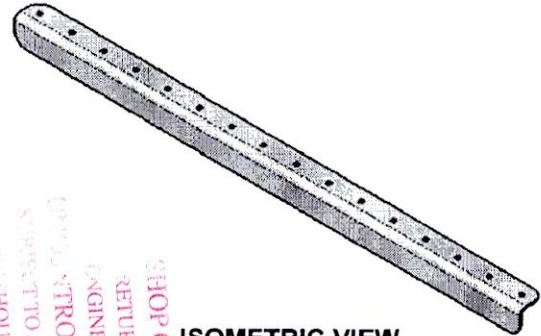
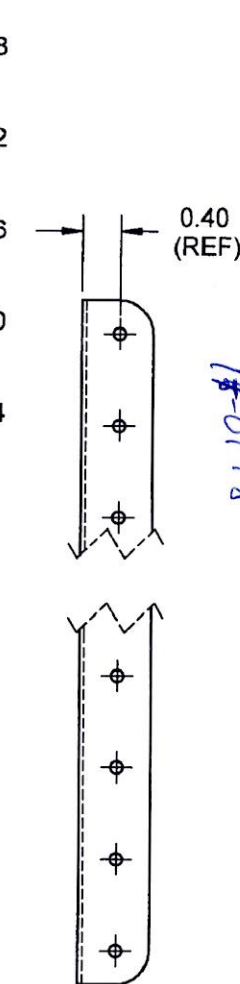
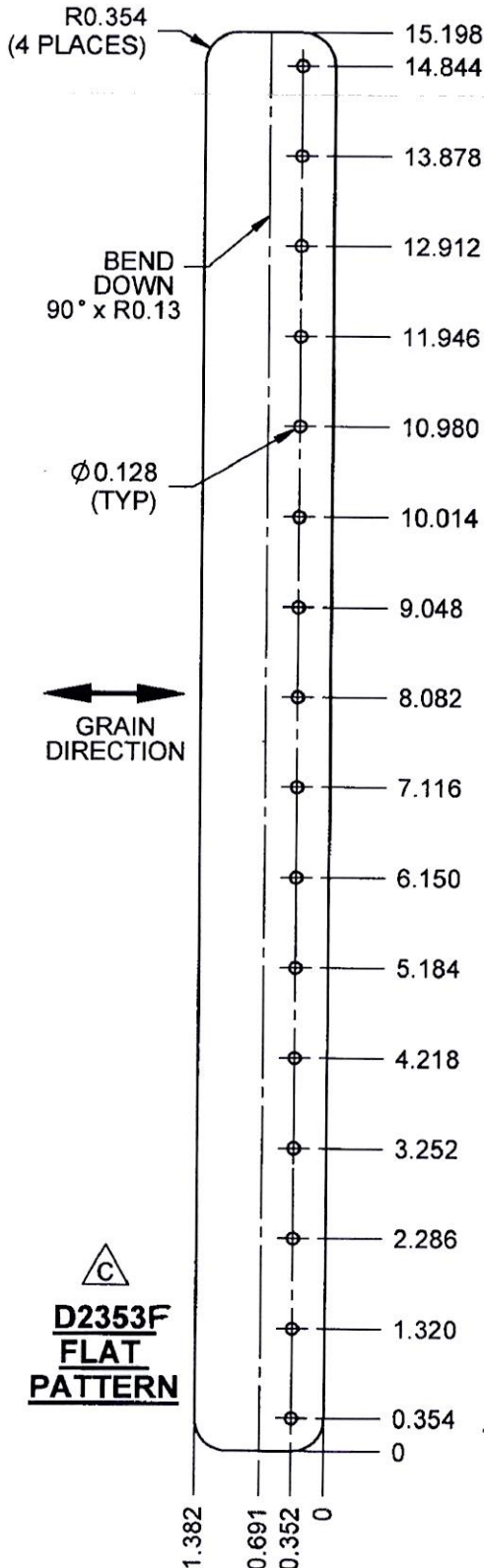
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DART

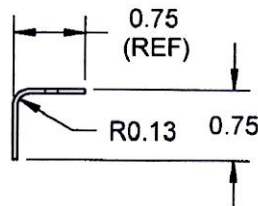
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13		TITLE STIFFENER	SCALE 1:2
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



**ISOMETRIC VIEW
SCALE 1:4**

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE
FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS
OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



RELEASED

06.11.28 [Signature]

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